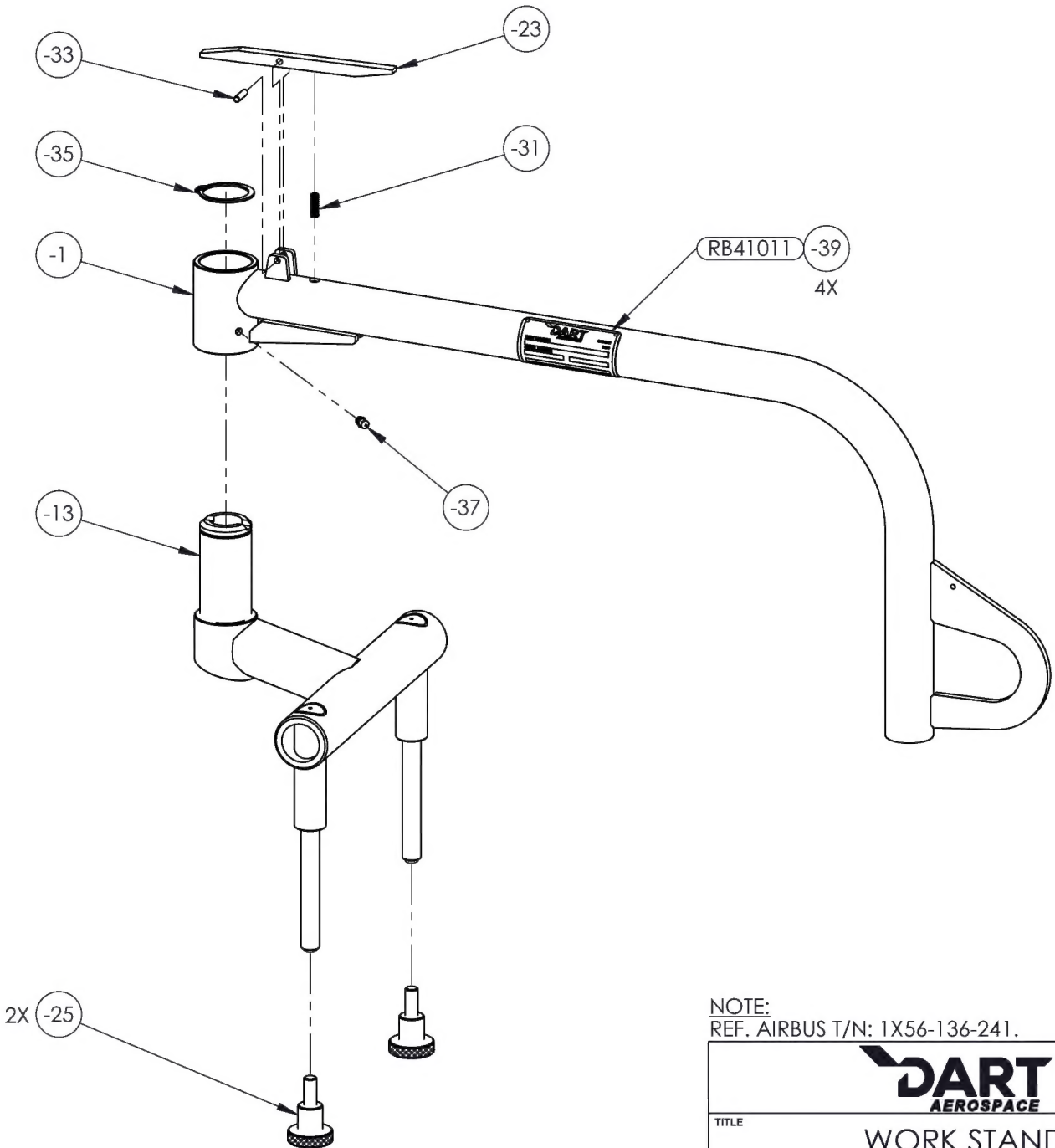
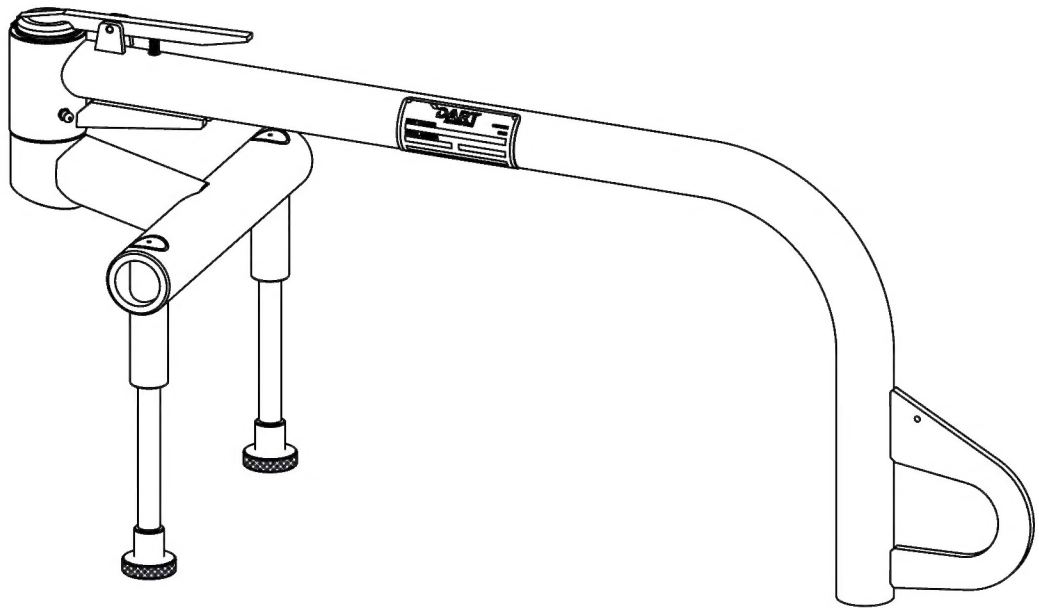


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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	9/20/2016	DPD	JAG



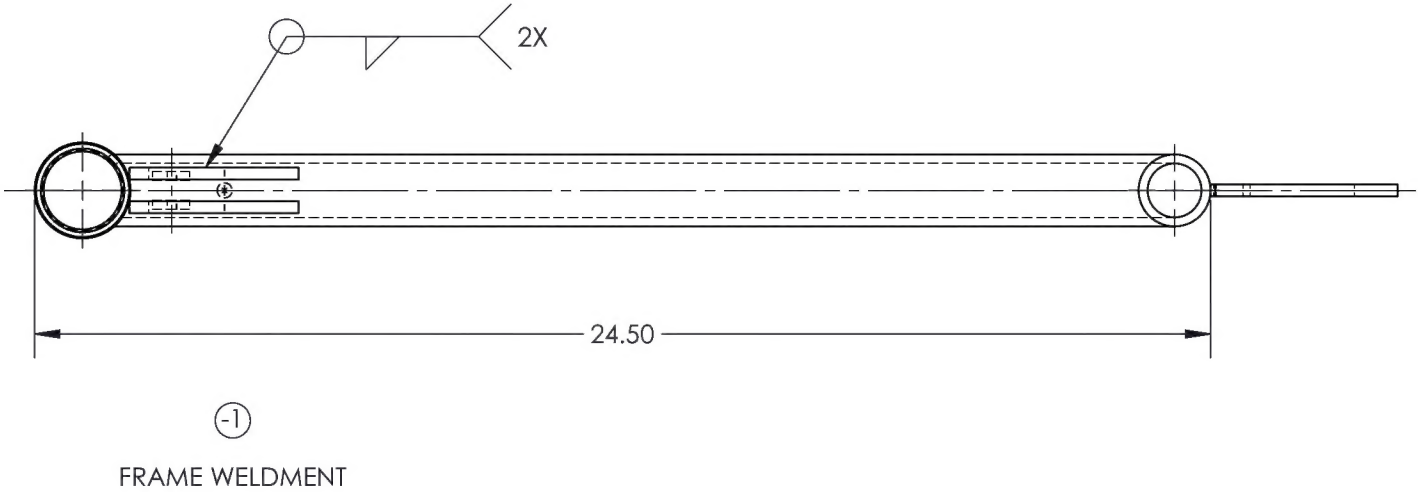
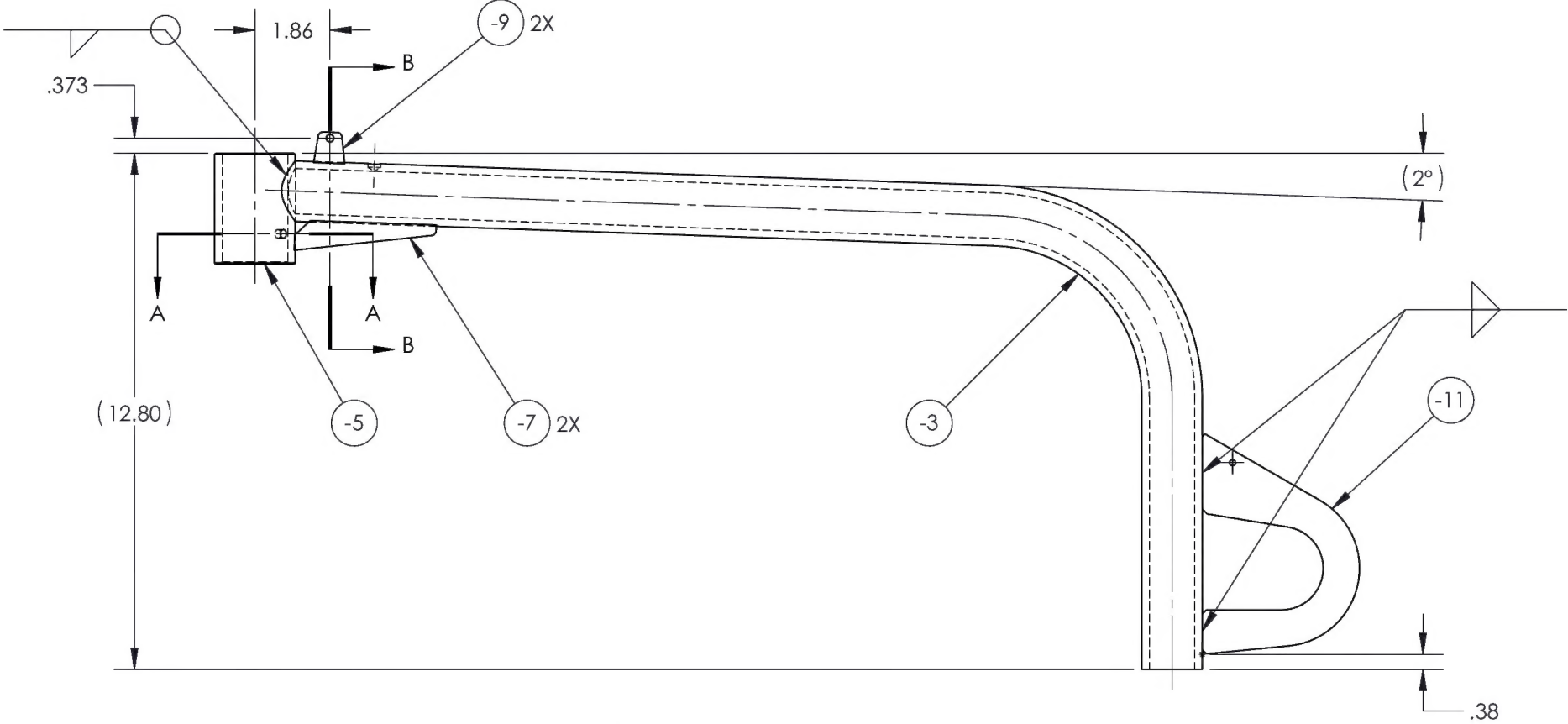
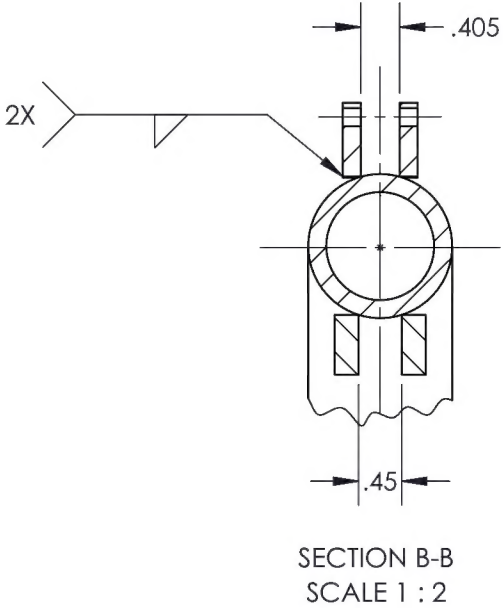
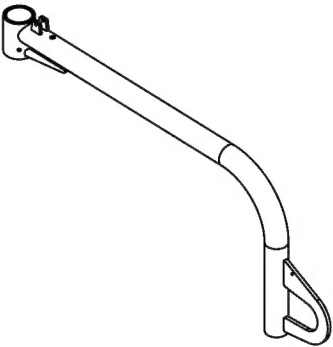
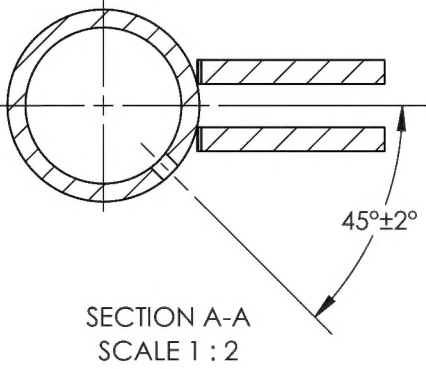
ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		X		-1	1	FRAME WELDMENT			2
		1		-3		MAIN TUBE	STEEL TUBE		3
		1		-5		SWIVEL TUBE	STEEL TUBE		4
		2		-7		SWIVEL TUBE GUSSET	A36/1018/1020 HR		5
		2		-9		LATCH BLOCK	A36/1018/1020 HR		6
		1		-11		PLATE	A36/1018/1020 HR		7
	X			-13	1	SWIVEL WELDMENT			8
	1			-15		SWIVEL	1018/1020 CR		9
	1			-17		MID TUBE	STEEL TUBE		10
	1			-19		PERPENDICULAR TUBE	STEEL TUBE		11
	1			-21		LEG	4140/4142		12
				-23	1	LATCH	1018/1020 CR		13
X				-25	2	FOOT WELDMENT			14
1				-27		FOOT	4140/4142		15
1			B/O	-29		THREADED ROD	STEEL	M10 X 1.5 X 50mm, GRADE B7 (MCMASTER-CARR #93675A330)	14
			B/O	-31	1	COMPRESSION SPRING	STEEL	Ø.032 WIRE X Ø.24 O.D. X 1, 16 LBS/IN (MCMASTER-CARR #9001T28)	1
			B/O	-33	1	DOWEL PIN	STEEL	Ø3/16 X 3/4 (MCMASTER-CARR #98381A508)	1
			B/O	-35	1	EXTERNAL RETAINING RING	STEEL	Ø1-9/16 SHAFT (MCMASTER-CARR #97633A390)	1
			B/O	-37	1	GREASE FITTING	BRASS	1/4-28 X 17/32 OAL (MCMASTER-CARR #3088K3)	1
			B/O	-39	4	#2 DRIVE SCREW	COATED STEEL	#2 X 1/8 (MCMASTER-CARR #90081A074)	1
			B/O		1	DART PLACARD	ALUMINUM	RB41011	1
ASSY -25	ASSY -13	ASSY -1							

NOTE:
REF. AIRBUS T/N: 1X56-136-241.

DART AEROSPACE		
TITLE WORK STAND		
DWG NO. RBE1X56-136-241	REV 1	
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
DRAWN BY: CHECKED: OPPS APPR: QA APPR: APPROVED:	DUERFELDT CLOUGH ANDERSON LINDSAY GILBERT	
SCALE 1:5	DATE 8/1/2016	USED ON MODEL H145 SHEET 1 OF 15

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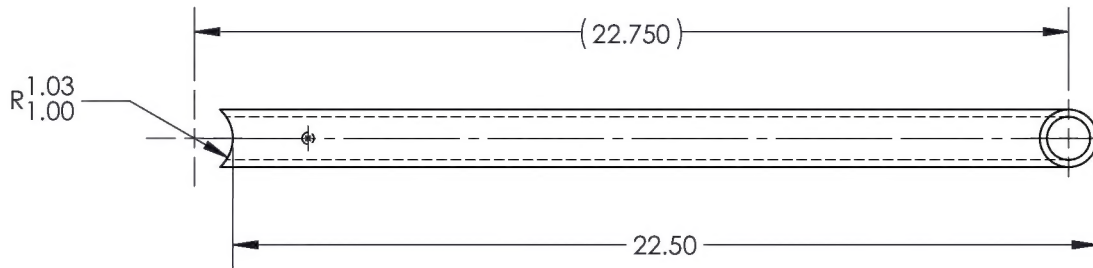
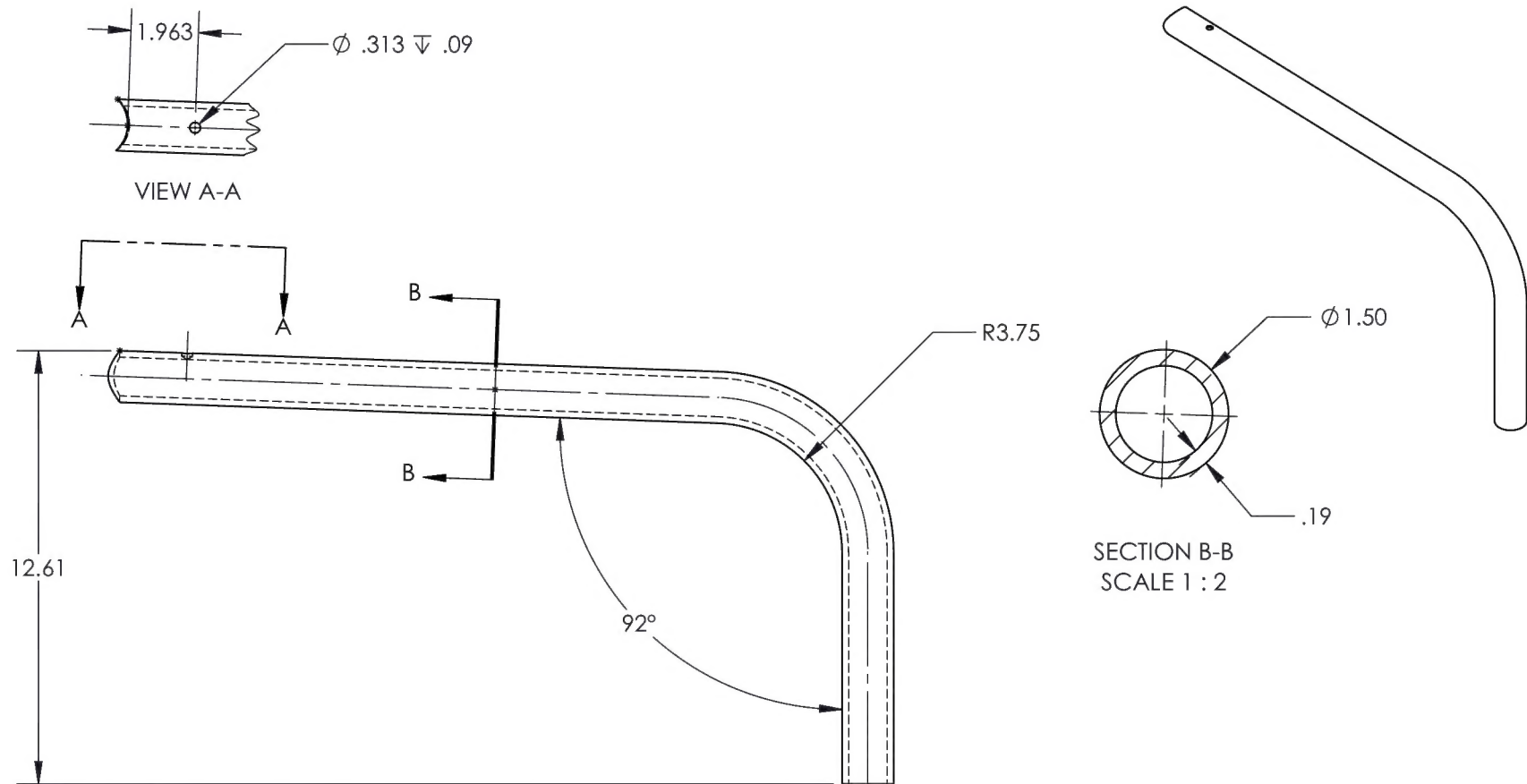
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



DART AEROSPACE			
TITLE WORK STAND			
DWG NO. RBE1X56-136-241-1			REV 1
MAT'L HEAT TREAT FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/	
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL H145	
APPROVED: GILBERT			
SCALE 1:4	DATE 8/1/2016	SHEET 2 OF 15	

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				APPROVED

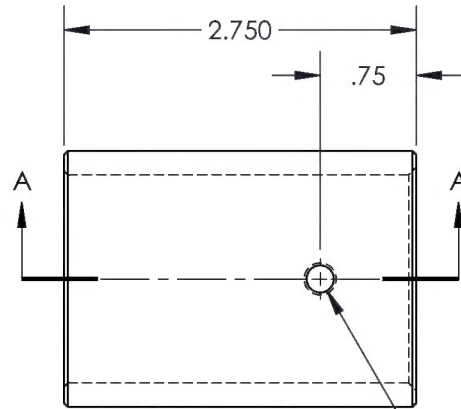
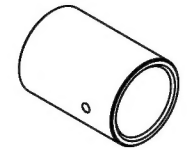


(-3)
MAIN TUBE

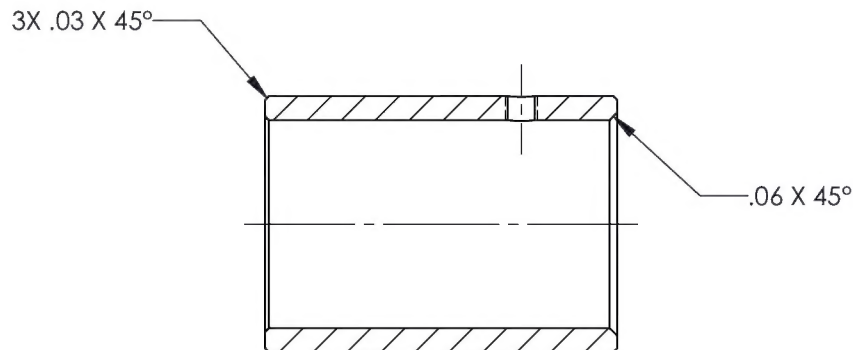
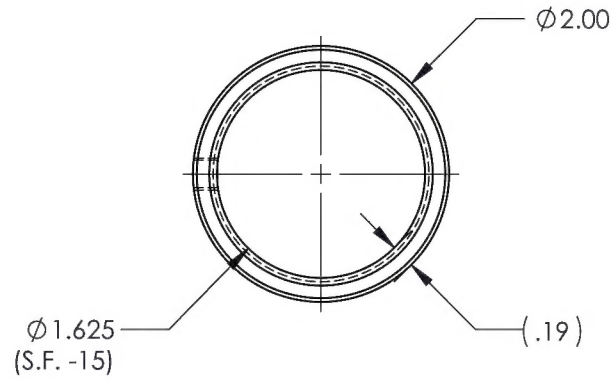
DART AEROSPACE	
TITLE WORK STAND	
DWG NO. RBE1X56-136-241-3	REV 1
MAT'L STEEL TUBE HEAT TREAT FINISH SEE -1 SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL H145
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:5	DATE 8/1/2016
SHEET 3 OF 15	

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				APPROVED



1/4-28 UNF - 2B ∇ 1.00



SECTION A-A

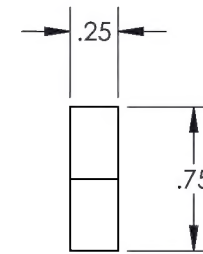
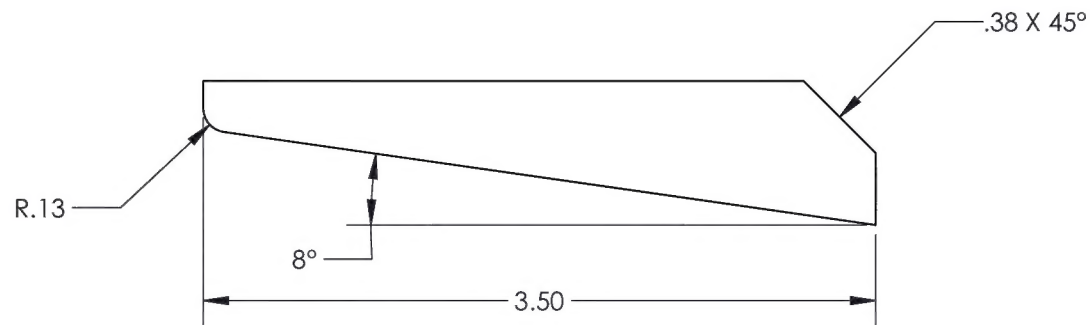
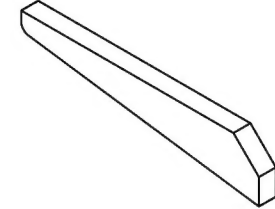
(-5)

SWIVEL TUBE

DART AEROSPACE	
TITLE WORK STAND	
DWG NO. RBE1X56-136-241-5	REV 1
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX \pm .010 FRACTIONS \pm 1/8
SPEC	.XX \pm .03 ANGLES \pm 1°
	.X \pm .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 2:3	DATE 8/1/2016
	SHEET 4 OF 15

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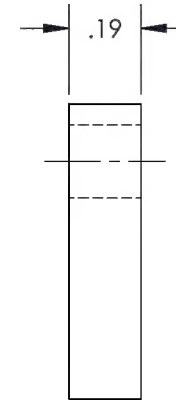
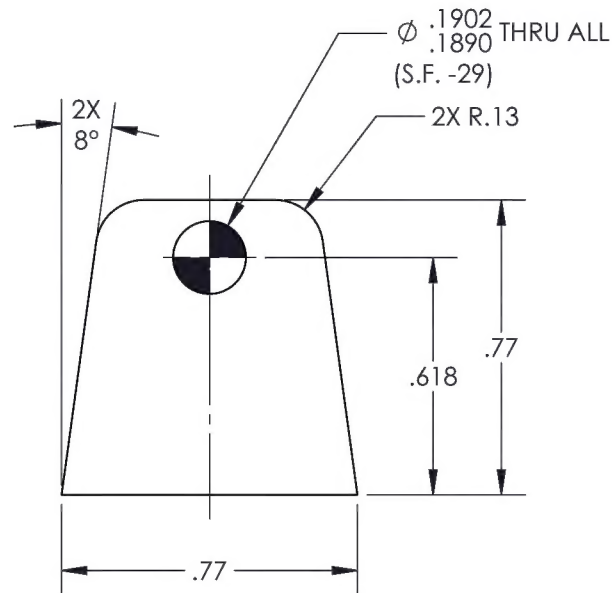
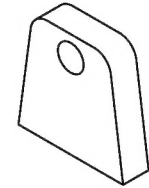


(-7)
SWIVEL TUBE GUSSET

DART AEROSPACE	
TITLE WORK STAND	
DWG NO. RBE1X56-136-241-7	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125° ✓
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 8/1/2016	USED ON MODEL
SHEET 5 OF 15	H145

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				APPROVED

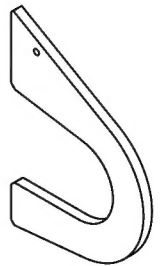
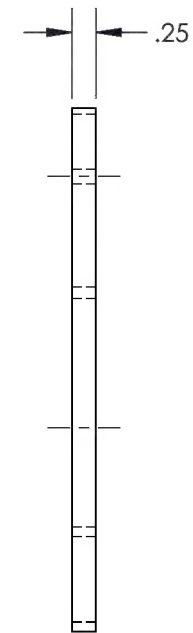
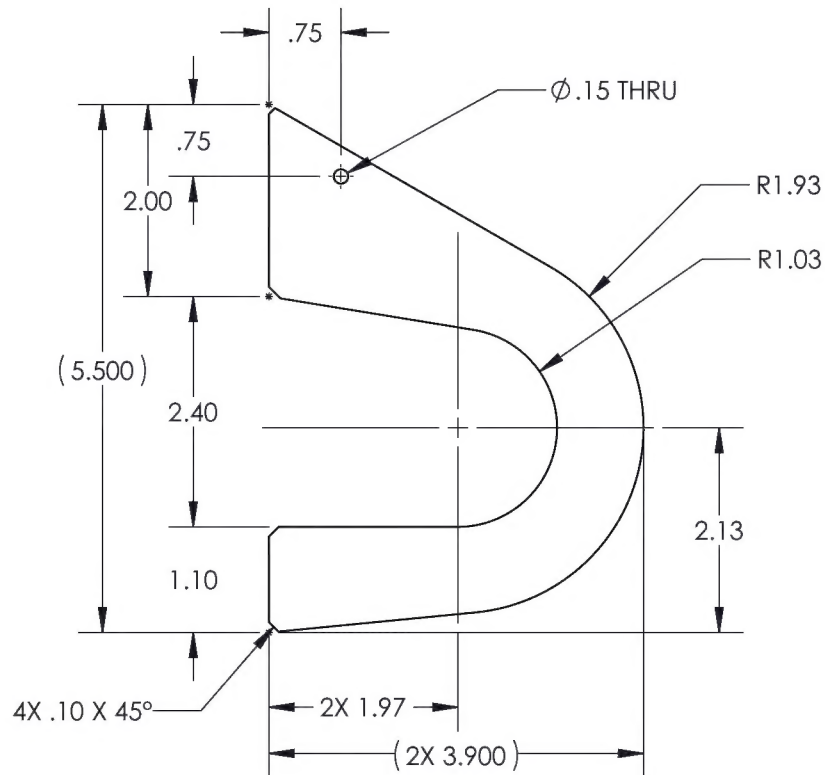


(-9)
LATCH BLOCK

DART AEROSPACE	
TITLE WORK STAND	
DWG NO. RBE1X56-136-241-9	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H145
SCALE 2:1	DATE 8/1/2016
	SHEET 6 OF 15

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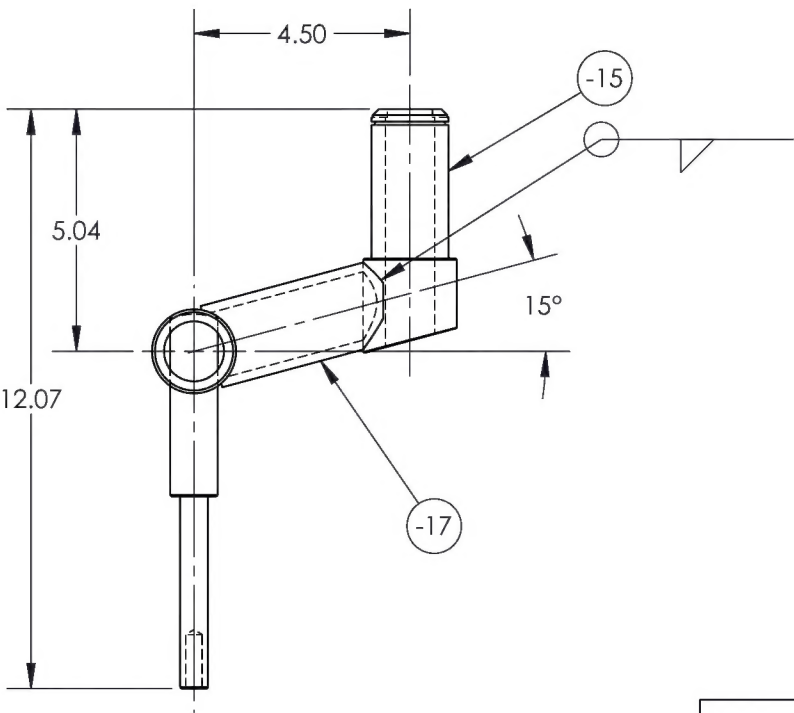
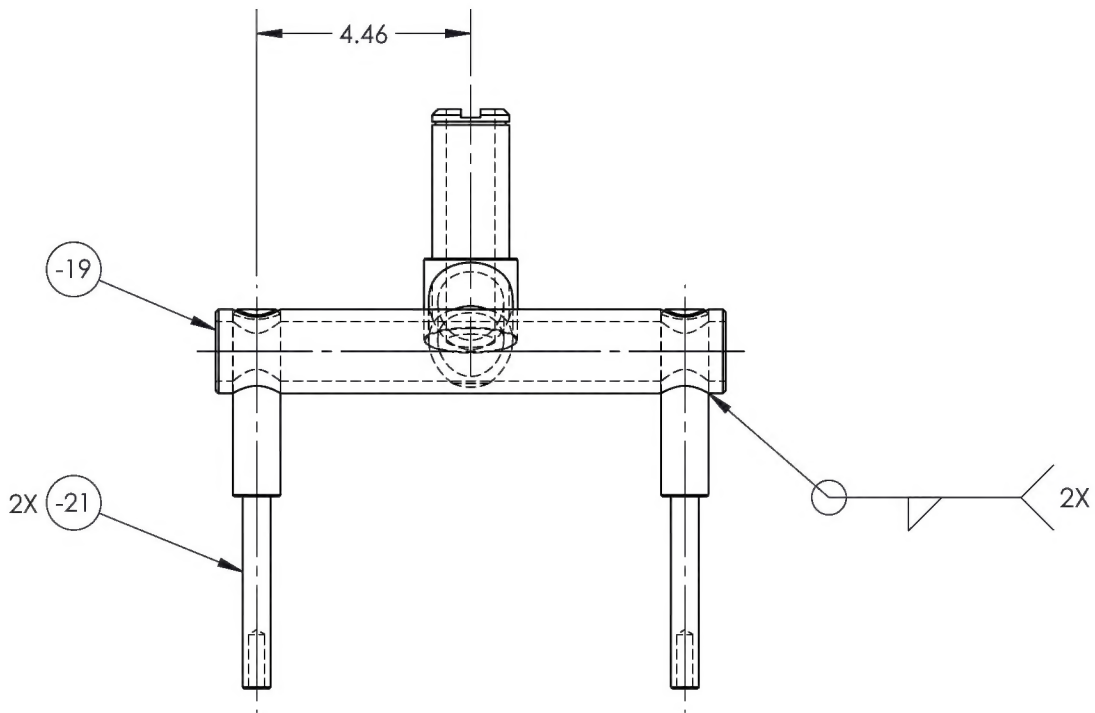
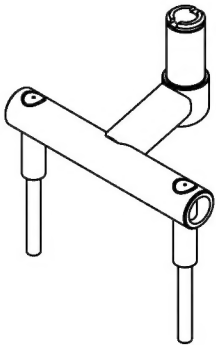
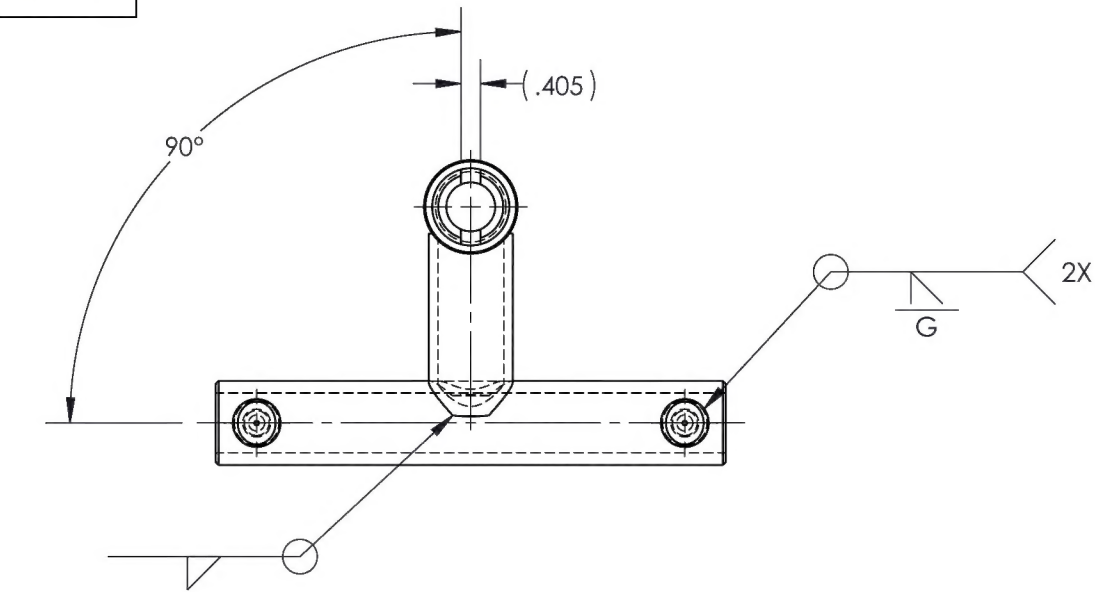
(-11)

PLATE

DART AEROSPACE	
TITLE WORK STAND	
DWG NO. RBEIX56-136-241-11	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H145
SCALE 1:2	DATE 8/1/2016
	SHEET 7 OF 15

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APPROVED				

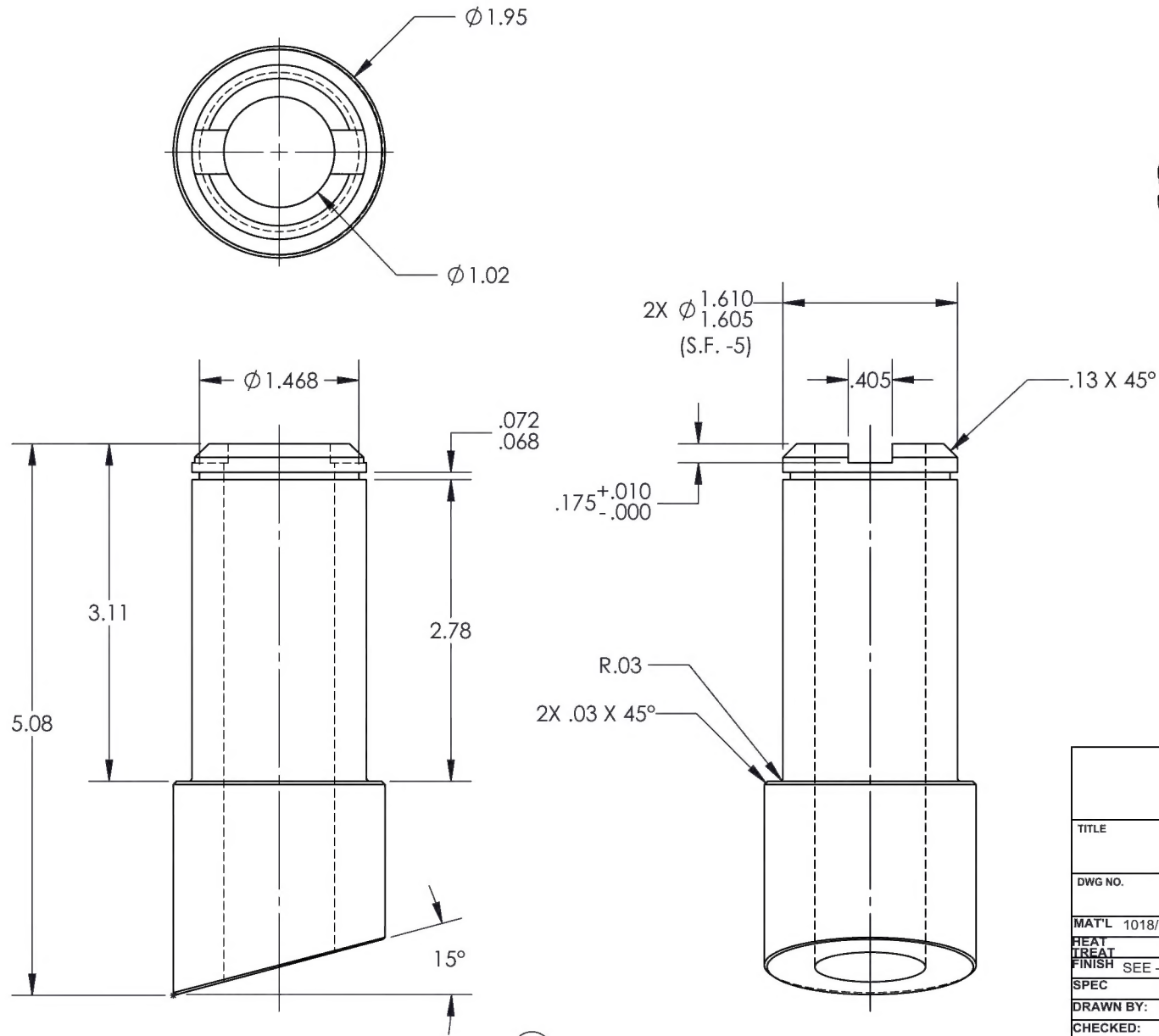


-13
SWIVEL WELDMENT

DART AEROSPACE			
TITLE			
WORK STAND			
DWG NO.			REV
RBE1X56-136-241-13			1
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH ZINC PLATE		.XXX ± .010 FRACTIONS ± 1/8	
SPEC ASTM B633 TYPE I SC 2		.XX ± .03 ANGLES ± 1°	
DRAWN BY: DUERFELDT		.X ± .1 SURFACES = 125✓	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:4		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 8/1/2016		USED ON MODEL	
SHEET 8 OF 15		H145	

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				APPROVED

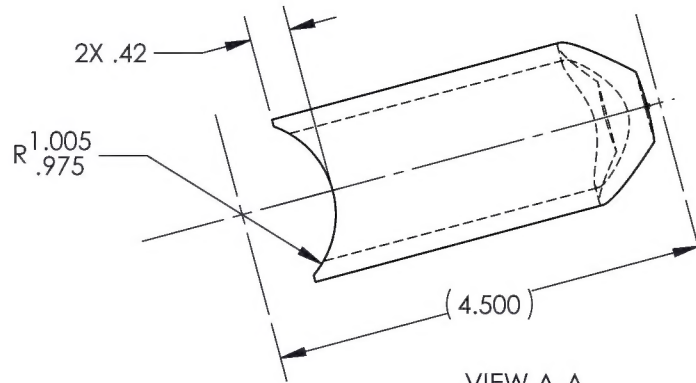


(15)
SWIVEL

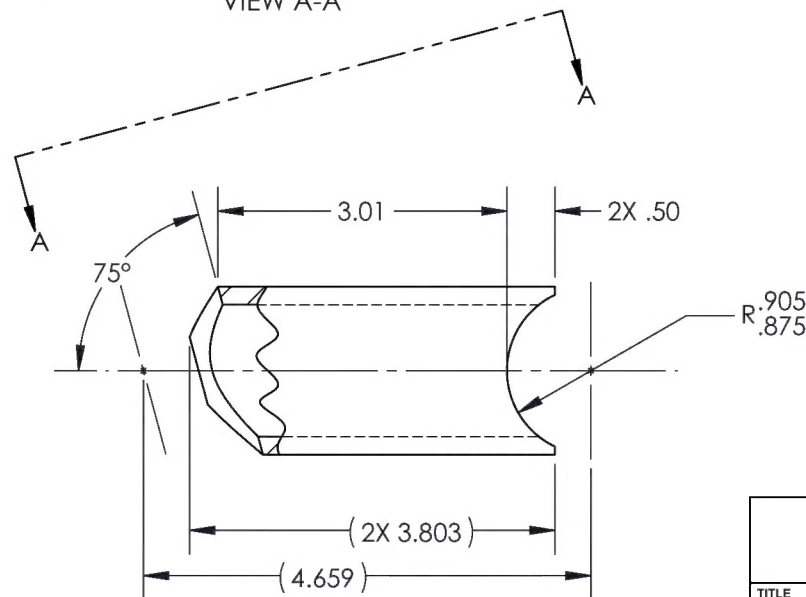
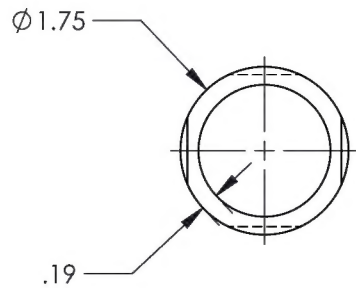
DART AEROSPACE	
TITLE WORK STAND	
DWG NO. RBE1X56-136-241-15	REV 1
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX \pm .005 FRACTIONS \pm 1/8
FINISH SEE -13	.XX \pm .01 ANGLES \pm 5°
SPEC	.X \pm .1 SURFACES = 125✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H145
SCALE 2:3	DATE 8/1/2016
SHEET 9 OF 15	

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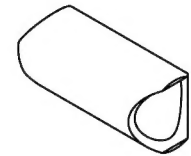


VIEW A-A



(-17)

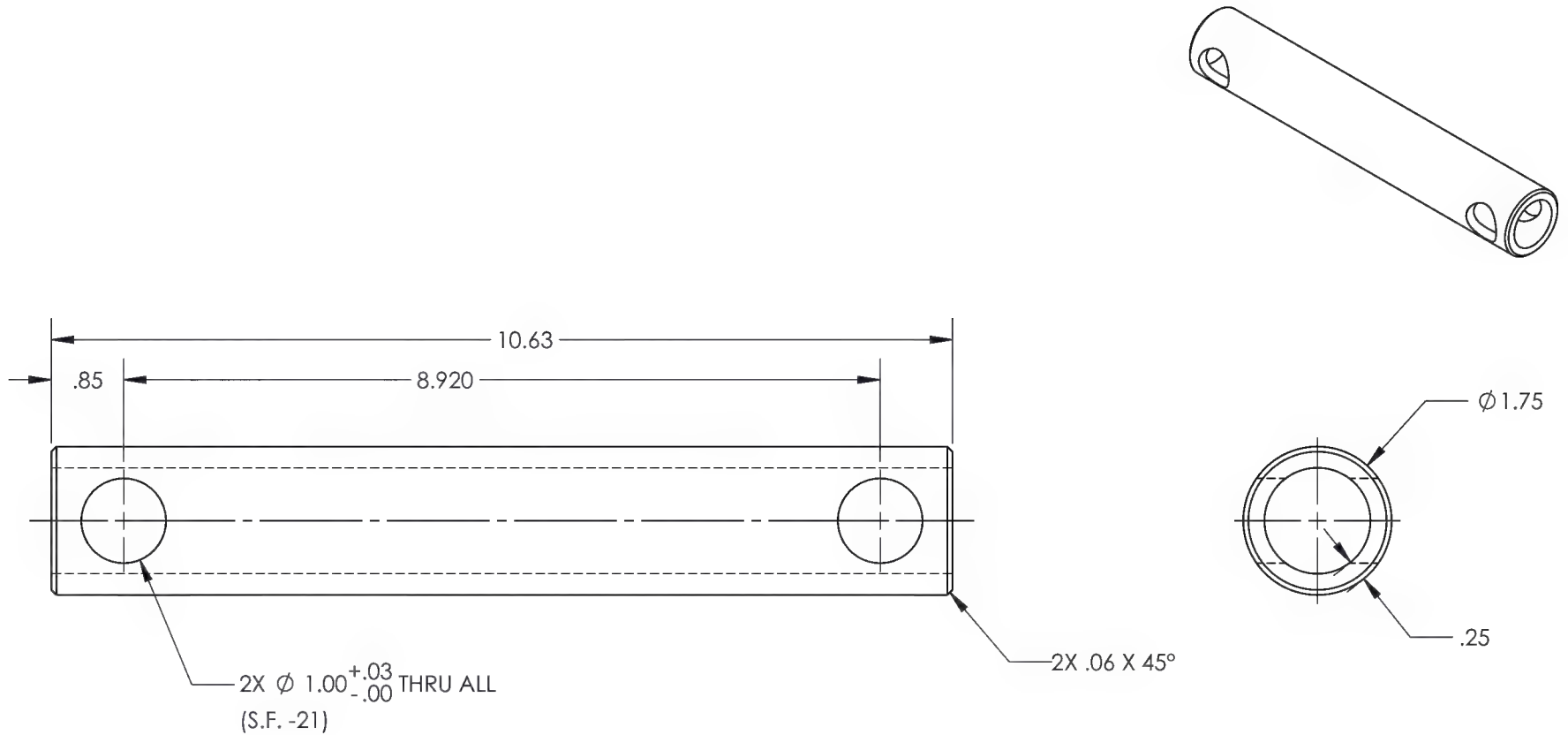
MID TUBE



DART AEROSPACE	
TITLE WORK STAND	
DWG NO. RBE1X56-136-241-17	REV 1
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -13	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H145
SCALE 1:2	DATE 8/1/2016
	SHEET 10 OF 15

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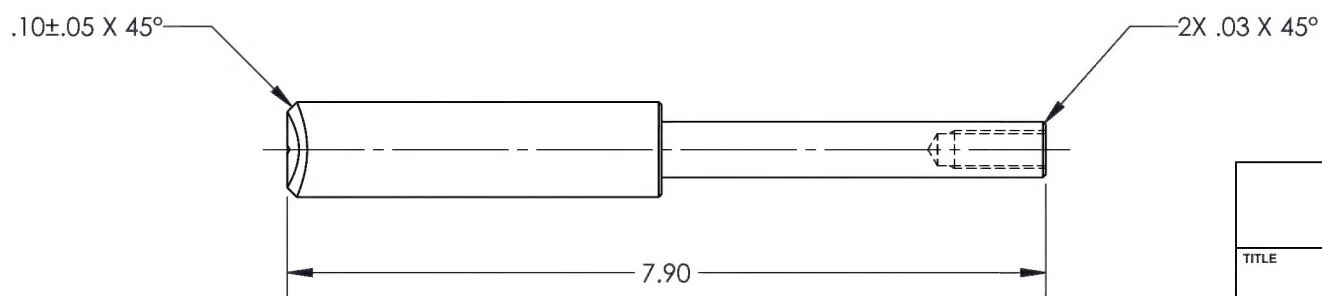
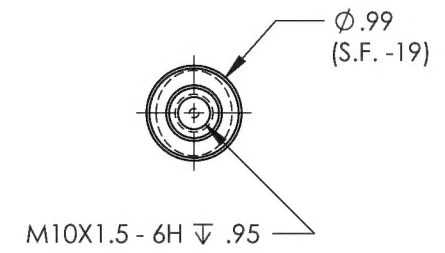
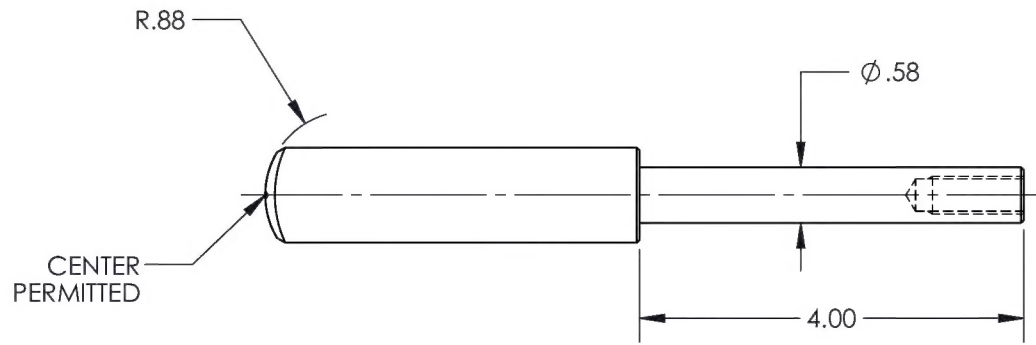
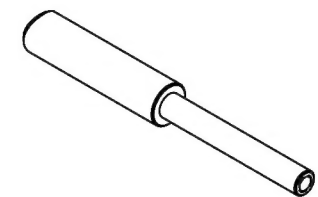


(-19)
PERPENDICULAR TUBE

DART AEROSPACE	
TITLE WORK STAND	
DWG NO. RBE1X56-136-241-19	REV 1
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -13	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H145
SCALE 1:2	DATE 8/1/2016
	SHEET 11 OF 15

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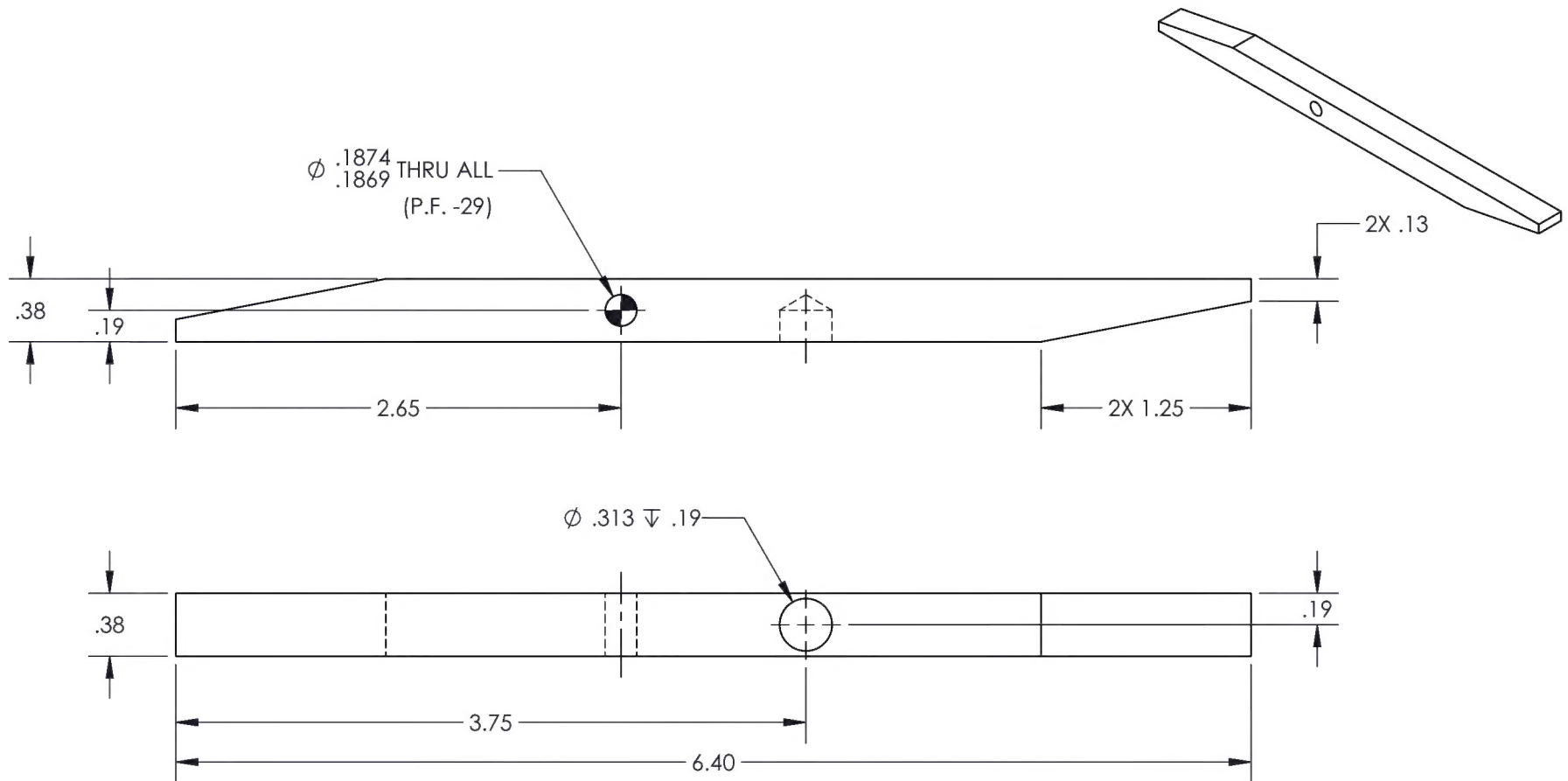


(-21)
LEG

DART AEROSPACE	
TITLE WORK STAND	
DWG NO. RBE1X56-136-241-21	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
TREAT RC 28-32	DIMENSIONS ARE IN INCHES
FINISH SEE -13	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125° ✓
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 8/1/2016	USED ON MODEL
SHEET 12 OF 15	H145

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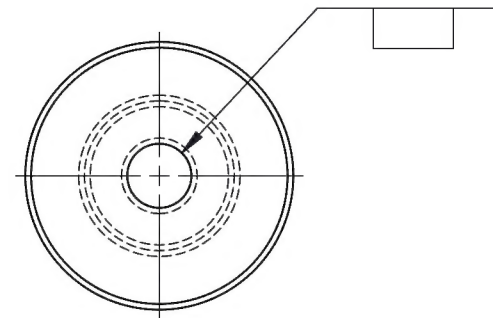
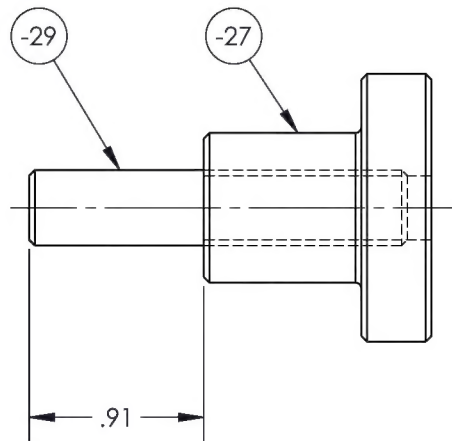
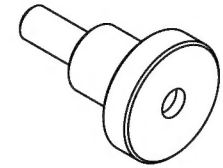


(-23)
LATCH

DART AEROSPACE	
TITLE WORK STAND	
DWG NO. RBE1X56-136-241-23	REV 1
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC ASTM B633 TYPE I SC 2	.XX \pm .01 ANGLES \pm .5°
DRAWN BY: DUERFELDT	.X \pm .1 SURFACES = 125°
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
	USED ON MODEL
	H145
SCALE 1:1	DATE 8/1/2016
	SHEET 13 OF 15

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



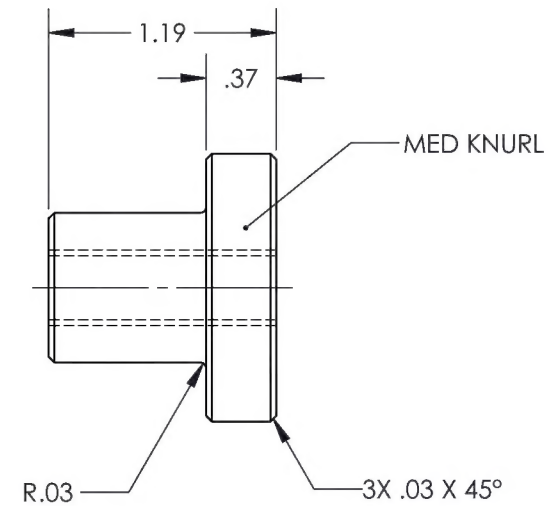
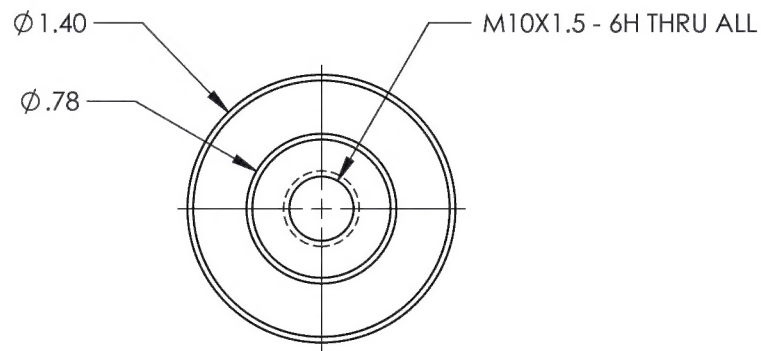
-25

FOOT WELDMENT

DART AEROSPACE	
TITLE WORK STAND	
DWG NO. RBE1X56-136-241-25	REV 1
MAT'L ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR:	USED ON MODEL
QA APPR:	H145
APPROVED:	
SCALE 1:1	DATE 8/1/2016
SHEET 14 OF 15	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-27)
FOOT

DART AEROSPACE	
TITLE WORK SLING	
DWG NO. RBE1X56-136-241-27	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT RC 28-32	DIMENSIONS ARE IN INCHES
FINISH SEE -25	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 8/1/2016	USED ON MODEL
SHEET 15 OF 15	H145